

54747 DRU

Work Order ID 53737

November 16, 2009 10:38:21 AM



Item ID: D3212-1	Accept		Setup Start	
Revision ID: B			Stop	
Item Name: Floor Window				
Start Date: 11/16/09	Start Qty: 6.00		Cust Item ID:	
Required Date: 11/20/09	Req'd Qty: 6.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>h</u>	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3212	Rev B								

100

 Waterjet
 FLOW CNC Waterjet
 FLOW WATER JET
 0.00
 Memo
 1-Cut blankas per Dwg D3212 ☒ Dwg Rev: B ☐ Prog Rev: B
☐
 2-Deburri if necessary

B 9-11-16

(16)

110

 HAAS 1
 HAAS CNC vertical machine #1
 HAAS CNC VERTICAL MACHINING #1
 0.00
 Memo
 Machine as per Folio FA349 and Dwg D3212

h 09.12.09

B 9-11-16

120

 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 0.00
 Memo
 0.00

h 09.12.09

(12) 4

15.308 x 9.215

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3212-1 PAR #: _____ Fault Category: Machined Parts NCR: Yes No DQA: [Signature] Date: 05-12-30
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 08-12-31

NCR: 53737		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-12-09	110	DRILLED CROOKED, OVERSIZED HOLES STACK OF 4 MISSUNDERSTOOD FOLIO, SOME TOOLING NOT IDENTIFIED. FOLIO CORRECTED. RC LCA.	[Signature]	SCAP X 4 DO NOT REPLACE, BLANKS CUT ON WATERJET NONE AVAIL. Rekin work re-inspected	[Signature] 09-12-09	[Signature] 09-12-10	[Signature]	[Signature]

NOTE: Date & initial all entries

Work Order ID 53737

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Item ID: D3212-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Floor Window

Start Date: 11/16/09 Start Qty: 6.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SB 09/12/14

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Deburr if necessary; 12-Install label as per Dwg D3212; 13- polish abrasion scratches if necessary.. 14-Wrap in plastic wrap after inspection

EP 09/12/15 *(12)* *(12)*

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 Sorkhatic

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53737

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Item ID: D3212-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Floor Window

Start Date: 11/16/09 Start Qty: 6.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location 210

0.00



Packaging

Memo

0.00

Packaging

9/12/17 122 SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/21

09-12-18
12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 16, 2009 10:38:20 AM

Page 1

Work Order ID: 53737

Parent Item: D3212-1RevB

Parent Item Name: Floor Window

Comments:

Start Date: 11/16/09

Required Date: 11/20/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2728-1RevB		Manufactured	No			100	Each	0.0000	0.0000			
Dart Logo label												
MACRLICS.125		Purchased	No			140	sf	89.7570	6.1547			
1/8" Polycast II Sheet												

EB 09/12/15
17.
13 9-11-16

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

89.757

110115

4

110633

17.2295

111711

67.7447

112888

0.7828

109570

(16)

~~10633~~
112888 X 12
109570 X 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

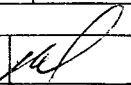
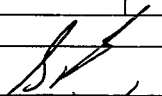
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53737
Description: FLOOR WINDOW		Part Number: 03212 - 1
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
13.59	+/- .030	13.59	✓			
12.734	+/- .010	12.734	✓			
6.367	+/- .010	6.367	✓			
.625	+/- .010	.625	✓			
.156	±.005 - 0.001	.156	✓			
12.25	+/- .030	12.25	✓			
8.462	+/- .010	8.462	✓			
9.09	+/- .030	9.09	✓			
.313	+/- .010	.313	✓			
8.150	+/- .010	8.15	✓			
3.750	+/- .010	3.750	✓			
1.31	+/- .030	1.31	✓			
1.13	+/- .030	1.13	✓			
1.312	+/- .010	1.312	✓			
6.260	+/- .010	6.260	✓			
12.520	+/- .010	12.520	✓			
15.14	+/- .030	15.14	✓			
4.59	+/- .030	4.59	✓			
3.750	+/- .010	3.750	✓			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 09.12.09	Date: 09/12/14	Date:	N/A

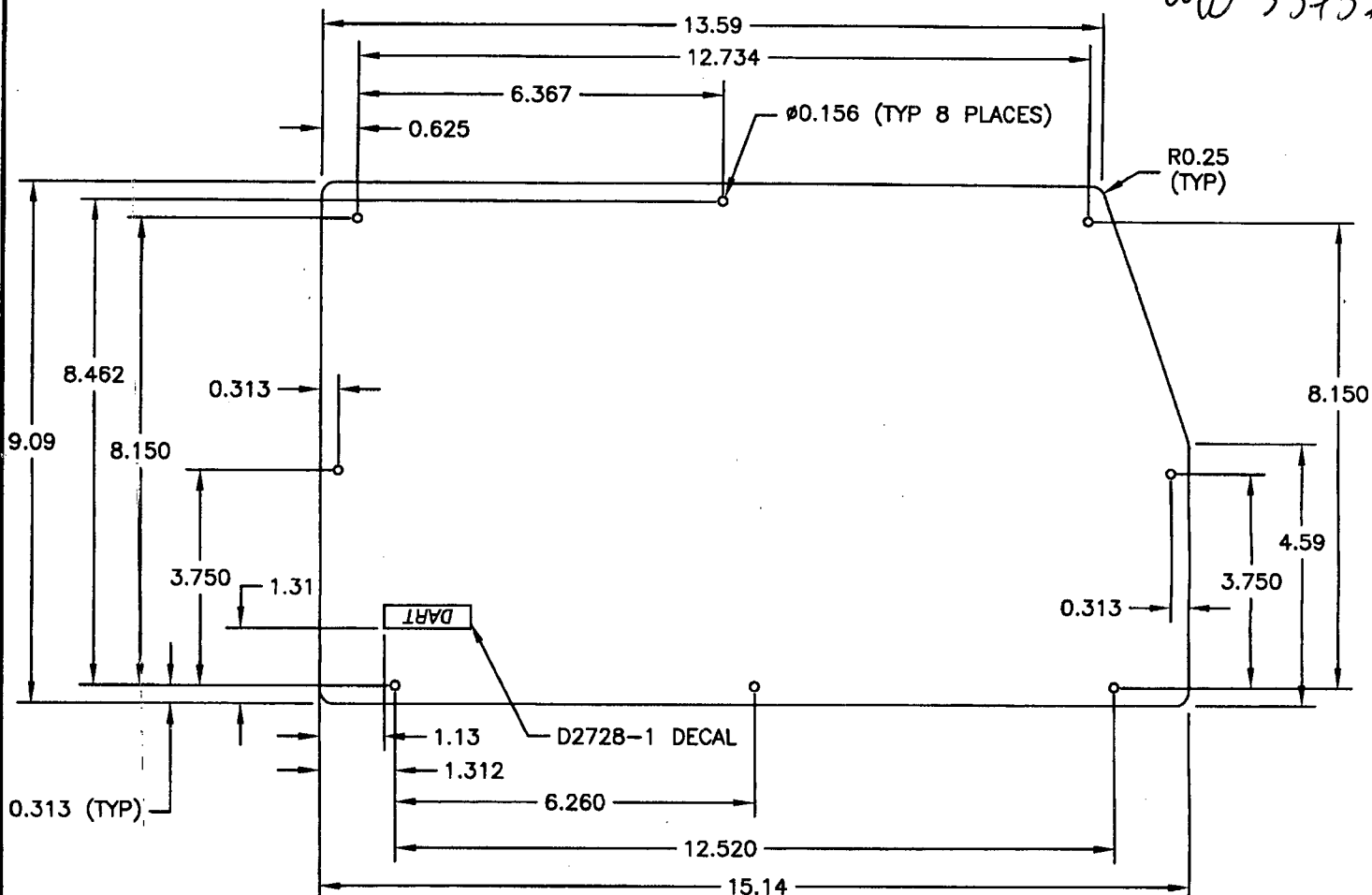
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	SSH	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.
				D3212
DATE	06.04.13	TITLE	FLOOR WINDOW	REV. B
				SHEET 1 OF 1
				SCALE
				1:3
A	03.09.03	NEW ISSUE		
B	06.04.13	UPDATE MATERIAL PER NCR 029		

D3212-1 FLOOR WINDOW

- 1) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
- 3) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



W/O: WORK ORDER CHANGES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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